



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400229-07
Job Sheet 173518



Part No: RBT400229-07

Job Qty: 10 ea

Part Name: Top



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400229 Rev 2 IPP Rev A 18.02.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/22/18	0.00	0.00	Start Up Machining-3		A.A 18-05-16
110	Mori Seiki	10 pcs		2/23/18	0.00	5.00	MORI NV5000-2		A.A 18-05-16
120	QC	10 pcs		2/23/18	0.00	0.00	QC2 Machining-4		A.A 18-05-16
130	QC	10 pcs		2/23/18	0.00	0.00	QC8 Machining-4		A.A 18-05-16
135	Outsource	10 pcs		2/23/18	0.00	0.00	Outsource1 ATLANTIC		A.A 18-05-16
140	Outsource	10 pcs		3/9/18			GRO002-VC	10	CT18-5-31
150	Packaging	10 pcs		3/9/18	0.00	0.00	Packaging2		A.A 18-05-16
160	QC	10 pcs		3/9/18	0.00	0.00	QC6		A.A 18-05-16
210	Packaging	10 pcs		3/9/18	0.00	0.00	Packaging3-1		A.A 18-05-16
220	QC21-SA	10 Ea		3/9/18	0.00	0.00	QC21		A.A 18-05-16

Part Op 110 - 1-Machine as per DWG. FB 967 FOLIO REV: 9-82 DWG REV: 9-82 2-Debur

Descriptions: 120 - Engrave T/N (RBT400229) and P/N (RBT400229-07) number using Marktronic engraver as per DWG.

ATLANTIC 135 - 1-Issue P/O to Metcore; P/O 0039140 RC 32-38 2-Bead blast 3- Certificate of Conformity is required

NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***

140 - -Issue P/O to Groupe Altech: P/O 040039 -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140NB1.500X3.000	4140 Steel Bar 1.500 X 3.000	4.9000 ft (.49 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140NB1.500X3.000	5	0	0

MT-4140-B-1.500X3.000
S055878

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ould not be found.

Plex 3/2/18 2:03 PM Dart.lajeunesse.marie



Container No: S072195



Part: RBT400229-07

Job No: 173518

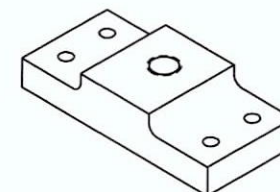
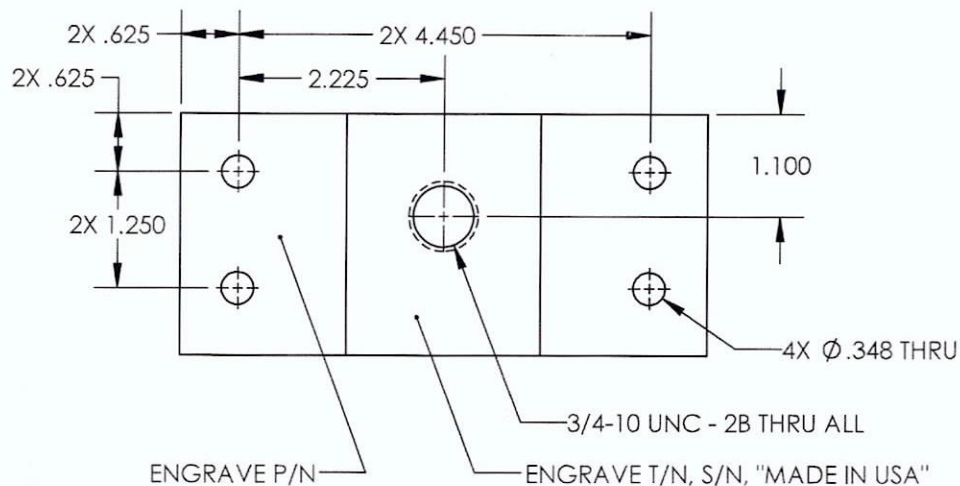
Serial No/Batch: S072195

Revision: 2

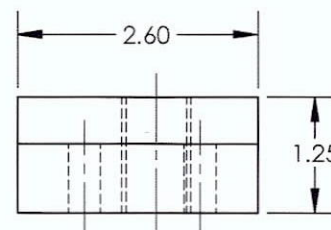
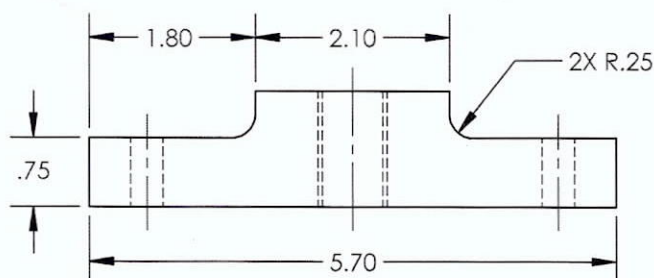
Inspector:

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0059	-07 CH'D DIM WAS R.250 (x2) IS 2X .25; REMOVED DIM 2.85, 1.05; ADDED DIM 1.80, 2X .625; CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416, TYPE II, CLASS II IS ZINC PLATE ASTM B633, TYPE I SC 2; CH'D MAT'L WAS 4140 IS 4140/4142.	3/15/2017	SM	JAG



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173518 MJS
1803-02



(-07)
TOP

DART AEROSPACE	
TITLE PULLER ASSEMBLY	
DWG NO. RBT400229-07	REV 2
MATL 4140/4142 HEAT TREAT RC 32-38 FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 03/17/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 03/20/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 03/29/2017	USED ON MODEL
APPROVED: JAG 04/06/2017	BELL 407
SCALE 1:2	DATE 8/2/2010
SHEET 5 OF 7	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																		
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				Lead hand / Supervisor Approval Verification																																																																		
				QC / QA Coordinator Approval																																																																		
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039948**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO039948
PO Date: 5/18/18
Due Date: 5/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171765	RB T102137-107-103	Strap 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 32-38 2-Bead blast 3- Certificate of Conformity is required Material 4140	Firmed	5/29/18	6 pcs	0 pcs 6x	6 pcs	\$13.195/pcs AT 18/05/31	\$79.17
2	173518	RBT400229-07	Top 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 32-38 2-Bead blast 3- Certificate of Conformity is required Material 4140 ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech***	Firmed	5/29/18	10 pcs	0 pcs 10x	10 pcs	\$8.513/pcs AT 18/05/31	\$85.13
3	177022	C3-12-3	Lock - C3 Hook 1--Issue P/O to Metcore ; P/O _____ RC 44-46 2-Bead blast 3- Certificate of Conformity is required Material 4140 ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech or ATG***	Firmed	5/29/18	4 pcs	0 pcs 4x	4 pcs	\$18.75/pcs AT 18/05/31	\$75.00
Grand Total:										\$239.30

Order Notes

CT

Certification

Date: 25/05/2018

Entry Date: 25/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: po039948

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
10	10 pcs material 4140 annealing and heat trt 32-38 rc c of c sand blast prt# rbt400229-07	37

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE 32. 38. 37. tested as per sampling
heated to 37rc with sand blast as per cust requested

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040059**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040059
PO Date: 5/31/18
Due Date: 6/6/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173852	RBE350A93-3300-20	Tail Rotor Hub Socket -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	12 pcs	0 pcs	12 pcs	\$3.79/pcs	\$45.48
2	177469	RBE350A93-3400-00-1	Guide -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	12 pcs	0 pcs	12 pcs	\$3.20/pcs	\$38.40
3	173354	RBT400313-7	Bolt -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	7 pcs	0 pcs	7 pcs	\$1.75/pcs	\$12.25
4	176875	C2-3-3	Latch Roller -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	6/5/18	19 18 pcs	0 pcs	19 pcs	\$10.4347/pcs	\$198.26

Plex 6/1/18 4:24 PM dart.tsimiklis.chrisoula

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	173518	RBT400229-07	Top -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	6/5/18	10 pcs	0 pcs	10 pcs	\$10.55/pcs	\$105.50
6	177022	C3-12-3	Lock - C3 Hook -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 - Certificate of Conformity is required	Firmed	6/5/18	4 pcs	0 pcs	4 pcs	\$10.4347/pcs	\$41.74
7	176605	D5230-5	Mounting Bracket Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O: _____ Black Anodize as per Dwg. D5230	Firmed	6/5/18	10 pcs	0 pcs	10 pcs	\$6.00/pcs	\$60.00
8	177468	RBE350A93-3307-00-03	Washer -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	6/5/18	30 pcs	0 pcs	30 pcs	\$0.89/pcs	\$26.70
9	177466	RBE350A93-3303-02-5	Extractor Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	6/5/18	30 pcs	0 pcs	30 pcs	\$1.05/pcs	\$31.50
10	173919	RBE350A94-3700-C-07	Top -Issue P/O to Groupe Altech: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A94-3700-C-07 Rev 6 -Certificate of Conformity is required	Firmed	6/5/18	30 pcs	0 pcs	30 pcs	\$4.00/pcs	\$120.00
11	177611	SWA3-300	Wire Clamp -Issue P/O to Groupe Altech: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	6/5/18	20 pcs	0 pcs	20 pcs	\$3.00/pcs	\$60.00
Grand Total:										\$739.83
Order Notes										

DAS
38
9-88



Certificat de Conformité / Certificate of Compliance

(009916-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009916 - 2

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
06-Jun-2018		Aman		040059				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
6	RBT400229-07 Rev.	RBT400229-07 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS TYPE 1 SC2	ZINC CH	10	10	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.